Work Order ID 99725

April-11-13 2:58:59 PM

Quality Control

Page 1

Accept Item ID: D3912-5 Setup Start **Revision ID:** Stop Eyebolt Plate Item Name: *10* **Start Oty: 10.00** Start Date: 4/12/13 Cust Item ID: Reg'd Qty: 10.00 Required Date: 4/12/13 **Customer:** Reference: Run Process Plan: _ ML3 Date: 13-04-15 Tooling: Date: _ _ Approvals: Stop Date: SPC (Y/N): Date: Tool # Plan Reject Reject Sequence 1D/ Set Up/ Tool ID Accept Insp. Operation Work Center ID Description Run Hours Code Qty Qty Number Stamp Draw Nbr Revision Nbr В D3912 0.00 100 *100* 0.00Waterjet Memo Cut as per dwg D3912 FLOW CNC Waterjet Prog Rev: Dwg Rev: Deburr as required 110 QC2- Inspect parts off machine FAI/FAIB 0.00 *110* 10 6 _ Jm3-09-5 0.00 QC Memo

										DQA:	Date:			
NCR: Ye	s / No				WORK ORDER NON-C	CONFORMANCE / UPDATE QA Closed: Date:								
Work Order:	:				DISPOSITION				_	AINST DEPARTMENT/PROCESS				
Part No)				Rework Scrap			Skid-tube Machining	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other		
NCR No)				Use-as-is Work Order Update		inern	noforming Large Fab	Composite	Rec/sto	Supplier	Other		
Root				Descri	ption of work order update	П	Initial	Ac	tion	Sign &				
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector		
Doc/Data														
quip/Tooling								1						
Operator														
Material										 				
Setup														
Other														
Drocess -		1				Į.								

Landing (Gear	General		_	_	 _
	Bending	Bend		Grain	Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route		Hardware	Over/Under tolerance	Temperature/Cure
[_	Cracks	Broken/Damaged	Г	Inspection Incomplete	Part Incorrect	Weld
	Crushed/Crimped	Burrs		Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled
	Cuffs	Contamination		Maintenance	Part Moved	-
	Heat Treat	Countersink		Mislabeled	Positioned Wrong	 _
	Inspection Strip in Tube	Cut Too Short		Misread	Power Loss/Surge	Other
	Ripples in Bend	Drill Holes		Offset		
	Torque Waves in Extrusion	Drawing		Out of Calibration		
	Turning Sequence	Finish	Г	Out of Sequence		
	Wave/Twist in Tube	Folio	Г	Outside Dimensions		

FAULT CATEGORY

Supplier Training Unapproved

Work Ord April-11-13 2:		725		*997	'25*						Page 2
Item ID: Revision ID: Item Name:	D3912-5 Eyebolt Plate			Accept	*N900	040	100)* s	etup Star Stop	1 14	S1* S2*
Start Date: Required Date Reference:	4/12/13 e: 4/12/13	Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*		Cust Item II Customer:	D:					
Approvals:	Process Pla		Date:	Tooling:		nte:		R	tun Star Stop		R1* R2*
Sequence ID/ Work Center 120 *120 *CQC Quality Control	ID	Operation Description QC8- Inspect parts - second Memo	check	Set Up/ Run Hours 0.00 27 9-89	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Packaging Packaging		ldentify as per dwg & Stock Memo	Location: <u>144</u>	0.00				<u>/0x</u>	22)	13-09	9- <u>5</u> _
140 *140 * QC Quality Control		QC21- Final Inspection - W Memo	ork Order Release	0.00					13	19/0	14J-

pl 13.09.1

												DQA:	D:	ate:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UPI	DATE					
· · · · · · · · · · · · · · · · · · ·						·		_				QA Closed:	D.	ate:	
Work Ord						DISPOSITION				AGAINST D	EF	PARTMENT	/PROCESS		
Work Ord	er.					Rework		Skid-tube	Crosstube	٦	Water Jet			Engineering	
Part 1	Nο					Scrap	1	ŀ	Machining	Small Fab	┪	Pro	d. Eng. Coor	-	Quality
I dit	110.					Use-as-is	1	į.	noforming	Finishing	┪		re/Packaging	-	Other
NCR I	No.					Work Order Update	1 1	\$	Large Fab	Composite	7		Supplie	_	
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Root	1				Descri	ption of work order update		Initial	Act	tion	Ī	Sign &			
Cause		Date	Step	Qty		or Non-conformance	Cr	nief Eng	Descr	ription	╛	Date	Verification	on_	QC Inspector
Doc/Data			I								-				<u> </u>
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Operator				•	:		1				1				
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Setup	$ldsymbol{ld}}}}}}$														
Other							ı				ĺ				
Process				1			1								
Supplier															
Training											1				
Unapproved			<u> </u>	<u> </u>	<u></u>			T 6475			_1		L.,		<u> </u>
				india.	****		AUI	LT CATE	GUKY						<u> </u>
Land	ing (3	කිය	TE	_	General Bend	_	Grain		Г	7	Ovalized		_	Pressure/Forced
	\vdash	Bending	- .		o/c	BOM/Route	\vdash	Hardwa		⊢	1	Over/Under	tolorance	-	Temperature/Cure
Centre Not Concentric to O/S			-	\vdash	-	ire ion incomplete	<u> </u>	⊣	Part Incorred		\vdash	Weld			
			Broken/Damaged	-	- '	· ·	Linelane		Part Lost/Mi		\vdash	Wrong Stock Pulled			
	\vdash	Crushed/	crimped		-	Burrs	\vdash	Mainte	ions Incomplete/I	Unicieal	⊣	Part Moved	son ig	_	Twitonig stock runed
	-	Cuffs			-	Contamination	\vdash	Mislabe		⊢	-	Positioned V	Vrong		
	\vdash	Heat Trea		T L .	<u> </u>	Countersink	\vdash	-		⊢	_	Power Loss/	-		Other
1	1	Inspectio	n Strip in	Tube	1	Cut Too Short	1	Misread	,	1_		rower coss/:	ourge	<u> </u>	Louisi

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Drill Holes Drawing

Finish Folio

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Picklist Print

April-11-13 2:58:58 PM

Work Order ID:

99725

Parent Item:

D3912-5

Parent Item Name:

Eyebolt Plate

Start Date: 4/12/13

Required Date: 4/12/13

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP RevA: new issue DD 09.11.17 verified by:EC

Component Item ID/	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA 304/316 0.125 Sheet		Purchased	No	- 1.		100	sf	207.0300	0.05125	0:539474		Jr	ng-09-5

Location	Loc Qty	Loc Code	
MAT020	207.03		
122521	30.03		
\24445	177		124445

											DQA:	Da ⁻	te:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORI	MANCE / UPDATE					
									<u></u>		QA Closed:	Da	te:	
Work Orde	o r:					DISPOSITION			AGAINS	T DE	PARTMENT,	/PROCESS		
WORK Orde	er. –					Rework	1		Skid-tube Crosstub	_ آ_	ļ	Water Jet	Engine	eering
Part N	No.					Scrap	┨╏	Machining Small Fab Prod. Eng. Coor. Quality						
1011	•••					Use-as-is	┨		noforming Finishin	_	4	re/Packaging		Other
NCR No.			Work Order Update	1		Large Fab Composit		1	Supplier					
	_										<u></u>			
Root		-			Descri	ption of work order update	П	Initial	Action		Sign &			•
Cause		Date	Step	Qty		or Non-conformance	Ct	nief Eng	Description		Date	Verification	n QCI	nspector
Doc/Data														
Equip/Tooling	Ш										1			
Operator	Ц													
Material														
Setup	Щ													
Other	Ц		}		i									
Process	Ы													
Supplier	Н													
Training	Н													
Unapproved_	Ll		<u> </u>	<u> </u>	L		- 0 1 1	TCATE	CODY					
							AUI	LT CATE	GURT				•	
Landi		ear Bending			_	General Bend	Γ	Grain			Ovalized		Pressure	/Forced
	—	_	at Cansa	ntric to	O/5	BOM/Route	\vdash	Hardwa	aro.	\vdash	Over/Under	tolorance	—	ature/Cure
	Centre Not Concentric to O/S BOM/Route Cracks Broken/Damaged			\vdash	-1	ion Incomplete	\vdash	Part Incorred	1	Weld	ital cy cale			
	\vdash	cracks Crushed/i	Crimpad		<u> </u>	Burrs	-		tions Incomplete/Unclear	\vdash	Part Lost/Mi			tock Pulled
	${oldsymbol{ o}}$		Cimped		<u> -</u>	Contamination	\vdash	Mainte		-	Part Moved	221116		TOOK I WIICU
}	\vdash				Countersink	\vdash	Mislabe		\vdash	Positioned Wrong				

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	99725
Description: Eyebolt Plate	Part Number:	D3912-5
Inspection Dwg: D3912 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	10.005/.0.004		-	<u> </u>		
	+0.005/-0.001	0.130		<u> </u>	V	JAmoi
Ø0.257	+0.006-0.001	0.257	_		V	
0.38	+/-0.030	0.384			V	
1.500	+/-0.010	1.504,			V	
0.500 Pitch	+/-0.010	0503	_		ν	
3.15	+/-0.030	3,55			V	
0.375	+/-0.010	0.381	_		V	
0.517	+/-0.010	0.52			V	
1.000	+/-0.010	1.003	-			
3.65	+/-0.030	3.65"			_ V	
1.500	+0.020/-0.000	1.501			- V	
0.25	+/-0.030	0.3-53,	-		V	 :
2.00	+/-0.030	2.012			v	
0.125	+/-0.010	0,116"				
						
	 					
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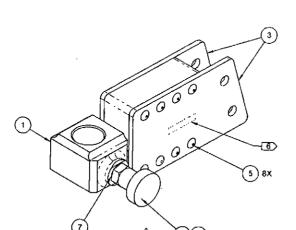
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Measured by:	Jm	Audited by:	9-89	Preliminary Approval:	
Date:	13-09-5	Date:	1395	Date:	

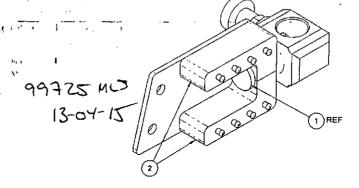
Re	èν	Date	Change	Revis	ed b	v	Approved
	1	10.06.07	New Issue	KJ	,		4 1
E	3	10.08.09	Dwg Rev updated	KJ	de	}_	
					- 1 	/ 	1-1-1-1

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пем.	QTY -041	PIN	DESCRIPTION		
	X	D3912-041	EYEBOLT RECEIVER ASSY		
_1 _	1	D3912-1	T TEYEBOLT		
2	2	D3912-3	EYEBOLT BLOCK		
3]	2	D3912-5	EYEBOLT PLATE		
4	1	D3801-1	SPRING PLUNGER	B	
5	8.	MS20615-4M20	RIVET		
6	1	MS21209-F615	HELICAL		
7	1	NAS1149F0332P	WASHER	β	





SUPPLEMENTAL ISO VIEW (EYEBOLT PLATE REMOVED TO SHOW INTERIOR FEATURES)

D3912-041 EYEBOLT RECEIVER ASSY

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NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING
FINE POINT PERMANENT: INK MARKER:

D3801-1 WAS D3810-1 SPRING PLUNGER; D4028-041 RMV; M521209-615 WAS M521209-0610 HELICAL; I1) WASHER NAS1149C0663R ADDED; BOSS ADDED TO D3912-1. 10 05 26 A NEW ISSUE JPH 10.03.04 REV. DESCRIPTION BY DATE

DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN CHECKED DRAWING NO. REV. B D3912 MFG. APPR. SHEET 1 OF 3 APPROVED TITLE SCALE EYEBOLT RECEIVER ASSY DE APPR. DATE

3

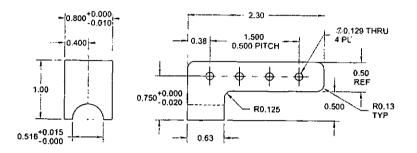
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COPYRIGHT © 2010 BY DART A EROSPACE LTD
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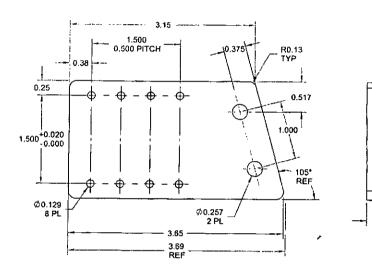
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D3912-3 EYEBOLT BLOCK



D3912-5 EYEBOLT PLATE

2.00

0,125 REF

AL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 REF DART SPEC M303B OR M304B	
-5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240 REF DART SPEC M303S11GA OR M304S11GA	

8

NOTES: 1) MATERIAL -3:

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2) FINISH: NONE
3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ID AT ASSEMBLY
7) WEIGHT -3: 0.30 lbs
-5: 0.24 lbs

DESIGN	7/5	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	.	
CHECKED	- 80	DRAWING NO.	REV. B	
MFG. APPR.	911	D3912 SHEE	T 3 OF 3	
APPROVED	149	TITLE	SCALE	
DE APPR.	_#	EYEBOLT RECEIVER ASSY	NTS	
DATE 10.0	6.28	COPYRIGHT O 2510 BY DART AEROSPACE LTD THE ECOLOGY SHEET, WO OPERISH, MO BE SUPPLY BY DEPART OF ORDER HOT TO BE USED FOR WITH ORDER OF CORRECTION TO TO JON PRICE PRINTED AT MY DEPART OF THE PRINTE		

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